

Date: Friday, 11/24/2006 8:54:59 AM
 User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 8" MIRROR
Job Number : 29690	
Estimate Number : 10103	
P.O. Number : N/A	Part Number : D2011103
This Issue : 11/24/2006 S.O. No. : N/A	Drawing Number : D2011 REV. F
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : F
Previous Run : 26938	Material : N/A
Written By :	Due Date : 12/1/2006 Qty: 50 Um: Each
Checked & Approved By :	
Comment : Est: J 04.09.15 Added Steps 5-7 KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: 2555

Velvac Mirror P/N: 708441

Possible supplier: UAP/NAPA

Material release note required

C206111124

(50)

2.0	708441	MIRROR 8"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
 Mirror 8"

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

64/4/29

(50)

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

11/06/12/04

(50)

5.0	D30153	Lock Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Locknut

Pick:

Qty Part Number Description Batch

1 D3015-3

Lock nut

628706

ml

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/12/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/24/2006 8:54:59 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 8" MIRROR

Job Number: 29690

Part Number: D2011103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD516 Washer

M 100564

ml ✓

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Discard Hardware & Install new hardware loosely

2- Inject 3ml of ^{white} ~~Black~~ Sikaflex adhesive per hole.

Qty Part Number Description Batch

A/R Sikaflex-291

Expiry date

M 1002107

02/2007

(50)

ml 06/12/04 ✓

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ML 06/12/04 (50) ✓

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1.

Identify and Stock

Location: ST204 25T205

LB 06/12/05 (50) ✓

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/05

Job Completion



U 06/12/05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector





Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

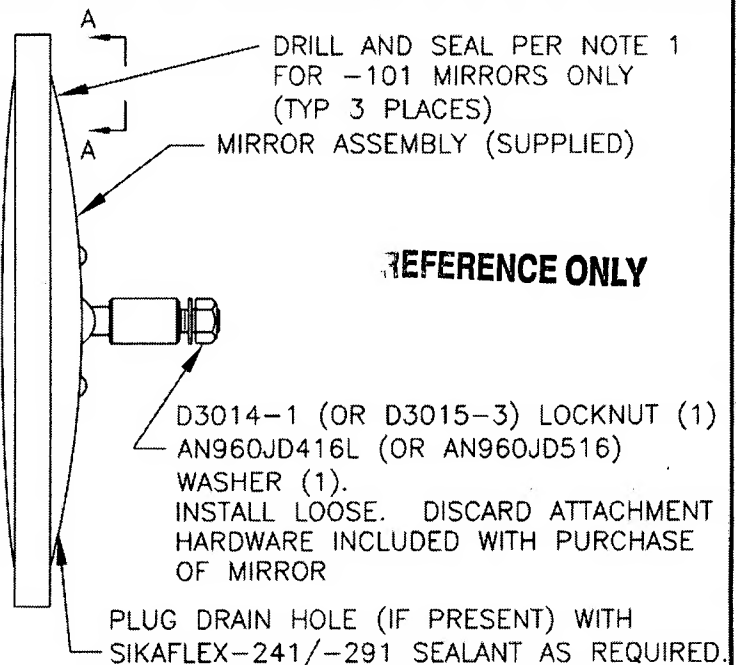
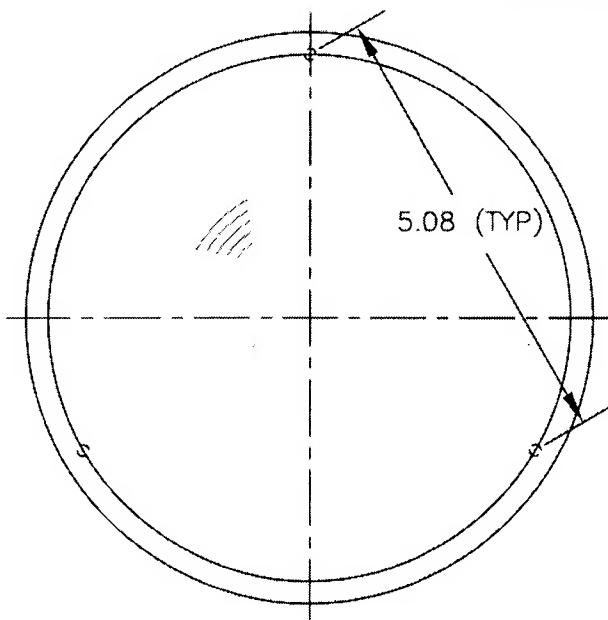
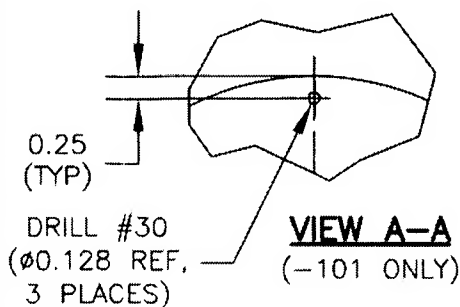
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN 		DRAWN BY 		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		DRAWING NO. D2011 REV. F SHEET 1 OF 1	
DATE 04.09.10			TITLE MIRROR ASSEMBLY SCALE 1:2		
—	90.03.31	NEW ISSUE			
A	90.06.15	DWG No. WAS DSP1011, ADDED -103			
B	98.04.09	SIKAFLEX 241 ADDED			
C	99.06.01	REPLACE DOMINION AUTO MIRRORS WITH PHILLIPS, ADDED STUDS, REDRAWN			
D	01.04.23	NEW 6" MIRROR, ADD NUT, RMV STUD			
E	01.05.08	NEW 8" MIRROR			
F	04.09.10	ADD HOLES FOR SEALANT ON -101			



QTY -101	QTY -103	Part Number	Description
X		D2011-101	MIRROR ASSEMBLY 6"
	X	D2011-103	MIRROR ASSEMBLY 8"
1		28043	MIRROR 6" (GROTE)
	1	708441	MIRROR 8" (VELVAC)
1		D3014-1	LOCKNUT
1		AN960JD416L	WASHER
	1	D3015-3	LOCKNUT
	1	AN960JD516	WASHER

NOTES:

- 1) ON -101 MIRRORS ONLY, DRILL QTY(3) Ø0.128 HOLES (REF) AS SHOWN AND INJECT SIKAFLEX-241/-291 SEALANT TO ENSURE MIRROR ADHERES TO HOUSING. TEST ASSEMBLY TO 50 LBS AFTER 24 HOURS.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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RELEASED
07.09.10

EMERGENCY TELEPHONE NUMBER 24 HOURS
CANUTEC 613-996-6666

ACCT #	SOLD TO	DATE	TIME	STORE #	EMP #	INVOICE N
01601	DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7	11/29/06	12:35	060004074	31	142336
SR #		PURCHASE ORDER #				ATTENTION
6		00002555				
AD		TAX EXEMPTION: 6122-5207				
25		TERMS: NET 30 DAYS CHARGE SALE				
		DELIVERY:				

PART NUMBER	LN	DESCRIPTION	QUANTITY	PRICE	NET	TOTAL
708441/	GRO	CONVEX MIRROR	50.00	29.950	23.950	1197.50 T

REFUNDED BY

Subtotal	1197.50
Tax 6% GST ONLY	71.85
Tax 0%	0.00

VERIFIED BY

Carol Lucas

SIGNATURE

SIGNATURE
ALL GOODS RETURNED MUST BE ACCOMPANIED BY THIS INVOICE

TOTAL → CHARGE SALE 1269.35

06/12/02